Work Order ID 121663

## \*121663\*

Page 1

Thursday, June	26, 2014 3:06:12 PM									
Item ID: Revision ID:	D3646-3		Accept	*N900	040	100	)*	Setup Star	. 17	S1*
Item Name:	Arm							Sto	, *N	S2*
Start Date:	6/26/14 <b>Start Qty:</b>	4.00 <b>*4*</b>		Cust Item ]	D:		,			
Required Date	: 6/26/14 Req'd Qty:	4.00 <b>*4</b> *		Customer:						
Reference:			•			_		D 04		
Approvals:	Process Plan: Mして	Date: 14-06-	<b>3</b> ♦ Tooling:	D	ate:			Run Star	~I <i>V</i> I	R1*
	QC:	Date:	SPC (Y/N):	D	ate:			Sto	*N	R2*
Sequence ID/ Work Center I	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3646	Rev C									
100			0.00						/	
*100*	NC BRAKE						4	<u> </u>	<del>}                                </del>	- - 14-07-1
Brake NC		emo	0.00				/			,
Brake NC	1-1	Punch to length as per Dwg D364	6 & template D18959							
110			0.00							
*110*	Small Fab	,					4		FF	14-07-1
Small Fab	M	emo	0.00	•						
Small Fab	1-7	Deburr2- Bend as per dwg D3646	5							
				Das						
120	QC5- Inspect p	part completeness to step on W/O	0.00	47 ) 19			(1			
*120* QC Quality Control	М	(emo	0.00 MH	117			<u>4</u>	_		

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DQA:			_ Date:			- WORK OPDER NON CONFORMANCE / LIPDATE										
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only										
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS				
Work Orde	er: .					Rework			Skid-tube	Crosstube	ī	Water Jet	Engineering			
Part N	No.				<del></del>	Scrap			Machining	Small Fab Finishing	4	d. Eng. Coor.	Quality Other			
NCR I	NCR No.								Composite							
Root	İ				Desc	ription of work order update	I	nitial	Act	tion	Sign &					
Cause	ı	Date Step Qty			or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector				
Design										:						
Doc/Data																
Equip/Tooling																
Handling/Pre		•														
Material								•		·						
Operator	Ш									:						
Offset/Setup	Ш															
Process	Ш								·							
Supplier																
Training	Ш	i														
Transport			1		,											
Unapproved			<u> </u>	<u> </u>					<u></u>		<u> </u>					
							FAI	JLT CA	regory							
Landi	ng (	Gear			_	General	_	1	•		1					
		Bending				Bend	<u> </u>	1	Program		Outside Dim	<u> </u>	Pressure/Forced			
	$ldsymbol{ldsymbol{ldsymbol{eta}}}$	Centre N	ot Conce	ntric		BOM/Route	<u> </u>	Grain		-	Over/Under	<del> </del>	Set-up			
		Cracks			<u> </u>	Broken/Damage/Defect	ļ	Hardwa			Part Incorre	<u> </u>	Temperature/Cure			
		Crimp/Ki	nk/Ripple	e/Wave		Burrs		4	ion Incomplete/U		Part Lost/M	issing				
	$\perp$	Cuffs			<u> </u>	Contamination	<u> </u>		tions Incomplete/	Unclear	Part Moved	. <i>.</i>	Wrong Stock Pulled			
		Crushing				Countersink		1	gned/off center	,	Positioned V	_	Jothor			
	<u>_</u>	Heat Tre				Cut Too Short	<u> </u>	Mislabe			Power Loss/	surge [	Other			
		1 '	n Strip in	Tube		Drawing	_	Misrea								
	Marks/Chatter		_	Drill Holes		Off-set										
	Turning Sequence				Finish	_	4	Calibration								
1	Wave/Twist in Tube			be		Fit/Function	<u> </u>	Out of	Sequence							

## \*121663\*

Page 2

Thursday, June	26, 2014 3:0	06:13 PM								
tem ID: Revision ID: Item Name:	D3646-3 Arm			Accept	*N900040	100	<b>)*</b> Se	etup Start Stop	*NS:	
Start Date: Required Date Reference:	6/26/14 e: 6/26/14	Start Qty: 4.00 Req'd Qty: 4.00		54* 54*	Cust Item ID: Customer:					
Approvals:		an:	Date:	Tooling:	Date:	_	Rı	ın Start Stop	*NR	
	QC:		Date:	<b>SPC</b> (Y/N):	Date:				*NR	<b>ノ</b> *
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty		Reject Ins Number Sta	sp. amp
130 *130* Powdercoat		Black Sandtex(Ref:4.3.5		0.00			44	19-	710 CI	
Powder Coating ;		SPART TIM 200	E: FINISH TIME	OVEN TEMPERATURE:			•			
140		QC3- Inspect Part Finish	ı	0.00 SM			Y			
*140* QC Quality Control		Memo		0.00 MM	91					
*150 *150*		ldentify as per dwg & St	ock Location	31-3600.00			c (x		1(1-7-	2/
Packaging Packaging		Memo		0.00			7^	/	4-1-6	<del>7  </del>

26 9-89

DQA: Date:							"DART						
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / U		ork Order up	odate only	AEROSPACE
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Work Orde	er: _						. 1			_	1		
						Rework			Skid-tube	Crosstube	0	Water Jet	Engineering Quality
Part N	۱o. <mark>-</mark>					Scrap			Machining	Small Fab Finishing	4	d. Eng. Coor. re/Packaging	Other
NCR I	۱o. <b>ـ</b>				·	Use-as-is Suspected Unapproved		inern	noforming Large Fab	Composite	Nec/3tol	Supplier	
Root					Desc	ription of work order update		nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design	in												
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator	Ш												
Offset/Setup	Ш				İ					. ,		:	
Process	Ш		ļ										
Supplier					1								
Training	Ц		1				Ì						
Transport											!		
Unapproved							<u></u>						
							FA	ULT CA	TEGORY				
Landi		Ì			_	General	_	1- " /			Outside Dim	onsions [	Pressure/Forced
	-	Bending			_	Bend	-	1	Program	-	Over/Under	<del></del>	Set-up
	Ш	Centre N	ot Concer	ntric	<u> </u>	BOM/Route	$\vdash$	Grain		-	Part Incorre	<del> </del>	Temperature/Cure
		Cracks			-	Broken/Damage/Defect	$\vdash$	Hardwa		n muslified	Part Lost/Mi		Weld
	-	Crimp/Ki	nk/Ripple	:/Wave	-	Burrs	-	4 '	ion Incomplete/U		Part Moved	1331118	Wrong Stock Pulled
		Cuffs			 	Contamination	-	4	tions Incomplete/	Ulicieal	Positioned V	L. Vrong	1 Triong Stock i allea
	_	Crushing			<u> </u>	Countersink	$\vdash$	-	gned/off center	<del> </del>	Power Loss/		Other
	$\vdash$	Heat Tre		<b>-</b> .	-	Cut Too Short	-	Mislab Misrea		L	Ti ower coss/	Jui 60 L.	10000
	Inspection Strip in Tube		<u> </u>	Drawing	$\vdash$	Off-set							
	Marks/Chatter		 	Drill Holes	$\vdash$	-1							
	<u> </u>	Turning S				Finish	$\vdash$	-1	Calibration				
1	Wave/Twist in Tube				Fit/Function	$\perp$	Out of	Sequence				<del></del>	

Work Order ID 121663

Quality Control

\*121663\* Page 3 Thursday, June 26, 2014 3:06:13 PM Accept \*N900040100\* Item ID: D3646-3 Setup Start **Revision ID:** Stop Item Name: Arm \*4\* 6/26/14 **Start Qty:** 4.00 **Cust Item ID: Start Date:** Required Date: 6/26/14 Req'd Qty: 4.00 \*4\* **Customer:** Reference: Run Start Date: **Tooling:** Date: Approvals: Process Plan: Stop SPC (Y/N): Date: QC: Date:\_ Reject Sequence ID/ Operation Set Up/ **Tool ID** Tool # Plan Accept Reject Insp. Qty Qty Number Stamp Description Code **Work Center ID Run Hours** 0.00 160 QC21- Final Inspection - Work Order Release MLJ 14-07-22 \*160\* 0.00 QC Memo

DQA:			_ Date:			,							"DART
QA Closed:			Date:			WORK ORDER NON	-CC	ONFO	RMANCE / UF		ork Order up	ndate only	AEROSPACE
QA Closeu.			Date.									<u> </u>	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
	•					Rework			Skid-tube	Crosstube	]	Water Jet	Engineering
Part N	١o.					Scrap		i	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	-				<del></del>	Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	١ο. ِ					Suspected Unapproved			Large Fab	Composite		Supplier	╛. 凵
Post	т				Dosc	ription of work order update		nitial	Acti	on	Sign &		T
Root Cause		Date	Step	Qty	Desc	or non-conformance	1	ief Eng	Descri		Date	Verification	QC Inspector
Design		Date	σιορ	Qty		or non comormance	<u> </u>	101 0118					
Doc/Data											·		
Equip/Tooling													
Handling/Pre			1										
Material													
Operator			1										
Offset/Setup											·		
Process													
Supplier							ļ						
Training													
Transport					,							·	
Unapproved			<u> </u>	<u> </u>	ļ				<u> </u>		<u> </u>		
							FA	ULT CA	TEGORY				
Landi	ng G	1				General		1 /-			]		Pressure/Forced
		Bending			<u> </u>	Bend	<u> </u>	4	Program	<u> </u>	Outside Dim Over/Under	<b> </b>	Set-up
		İ	ot Concer	ntric	<u> </u>	BOM/Route	$\vdash$	Grain		<del>                                     </del>	Part Incorre	<u> </u>	Temperature/Cure
	igspace	Cracks	. /5: 1	4		Broken/Damage/Defect	-	Hardwa		auglified —	Part Lost/M	<del> -</del>	Weld
		1	nk/Ripple	/wave	-	Burrs	-	4 .	ion Incomplete/Un tions Incomplete/U	<del> </del>	Part Moved	· -	Wrong Stock Pulled
		Cuffs			<u> </u>	Contamination Countersink	$\vdash$	4	gned/off center	/iicicai	Positioned V		
	$\vdash$	Crushing		•	-	Cut Too Short	$\vdash$	Mislabe	-	<del> </del>	Power Loss/		Other
	$\vdash$	Heat Trea	at on Strip in	Tuba		Drawing	-	Misrea		<u> </u>	7. 55, 2000/		_ <u>t</u>
	-	Marks/Cl	•	, une	$\vdash$	Drill Holes		Off-set			<del></del>		
	$\vdash$	i	Sequence		-	Finish		4	Calibration				
	一	1	vist in Tuk			Fit/Function		4	Sequence				

Thursday, June 26, 2014 3:06:12 PM

Work Order ID: 121663

\*121663\*

Parent Item:

D3646-3

\*D3646-3\*

Parent Item Name: Arm

**Start Date:** 6/26/14

Required Date: 6/26/14

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Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev. A new issue 07.07.25 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			110	f	497.5333	2.91	12.25263			
*M304TR	0.500	035*							**		FF	- 14	-07.16

304 RD Tube .500 x .035W

Location	Loc Oty	Loc Code	
MAT017	497.5333		
m126922	3		
m128084	65.3123		4
m128084 m128495	120		
m128833	120		
m129188	189.221		_55

12.2526

DQA:			Date:			WORK OPDER NON CONFORMANCE (LIPDATE										
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE  Work Order update only										
					·	DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	**************************************			
Work Orde	er:								CLUST A LITTER TO	^h	· }	Water Jet	Engineering			
Part N	lo			·		Rework Scrap Use-as-is		ı	<b></b>	Crosstube Small Fab Finishing	Prod Rec/Stor	Engineering Quality Other				
NCR N	lo				<del></del>	Suspected Unapproved	Large Fab Composite									
Root			" .		Desci	ription of work order update	1	nitial	Action		Sign &					
Cause		Date	Step	Qty		or non-conformance	Ch	Chief Eng Description		on	Date	Verification	QC Inspector			
Design																
Doc/Data													:			
Equip/Tooling																
Handling/Pre																
Material	_			÷1.5	<b>,</b>	•										
Operator	_								<b>*</b> *	•						
Offset/Setup	_															
Process	_			- تبكية			İ		•							
Supplier	_	-									·					
Training	_															
Transport																
Unapproved			<u> </u>	<u> </u>	<u>.</u>		L						<u> </u>			
						· · · · · · · · · · · · · · · · · · ·	FA	JLT.CAT	EGORY			<del></del>				
Landi					_	General	_	1 /-			Outside Dim		Pressure/Forced			
,	—	ending	÷		-	Bend	_	1	rogram	-	Over/Under		Set-up			
	—		ot Conce	ntric		BOM/Route	H	Grain		<del> </del>	Part Incorrec	<del> </del>	Temperature/Cure			
	-	racks	L /pt - d			Broken/Damage/Defect	-	Hardwa	re ion Incomplete/Unqui	alified	Part Lost/Mi		Weld			
	_		nk/Ripple	e/wave	-	Burrs	-	•	ions Incomplete/Uncl		Part Moved	· ·	Wrong Stock Pulled			
	—	Cuffs Countarink				$\vdash$	4	ned/off center		Positioned W	·	, , , , , , , , , , , , , , , , , , , ,				
	Crushing Countersink			Cut Too Short	$\vdash$	Mislabe			Power Loss/		Other					
	Heat Treat Cut Too Short Inspection Strip in Tube Drawing			-	Misread			1. 2 5000).								
	Marks/Chatter Drill Holes			Off-set						-						
	Turning Sequence Finish					$\vdash$	4	Calibration								
	_		ist in Tu			Fit/Function	Out of Sequence									
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## DART AEROSPACE LTD

DAR

JANI ALIN	JJFACE					*	AEROSPA
Description: A	RM					Work Or	der: 121663
							5 2 / 11/2
nspection Drawing:	D360	, 6	Rev:	<u> </u>		Part Num	ber: D3646-3
		181	CDEC	TION	CUEET		
	1				SHEET		Comments
rawing Dimension	Tolerance A	tual Dimension	Accept	Reject	Method of	Inspection	COMMITTEE
26.50	0.030	26,50	V		S-Fa		
5.75	0.030	5.73	V		5- Fa	p-07	
2,50	0.030	2.50	V	<u> </u>	5-ta	b-07	
45°	10 -	45"	U			b10	
15"	10	150	1		5 - Fa		
30°	10	30°	V		S-Fa	6-05	
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	l		<u> </u>				
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acurad by:	Ch		AS	QC inst	ectorias		Engineering Approval (if necessar)
asarea by. JT			89		27		
asured by:	16		-		9-49	,	
e '/ / /.	Da	te _ / /		Date	1.6	110	Date